

Work Order ID 86396

86396

Page 1

June-27-12 4:08:15 PM

Item ID: D3929-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Gusset Assembly

Start Date: 27/06/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 03/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: MLS Date: 12/06/28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3929

Rev A

100

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3929

Dwg Rev: A

Prog Rev: A

304.125"

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

6 0 Jm 12-6-29

6 0 Jm 12-6-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00							
120 QC Quality Control	Memo	0.00	8/26/13			(76)			
140		0.00							
140 Large Fab Large Fab	Memo	0.00				12-7-23			
	Weld bushings D3907-1 as per dwg D3929								
	316L rod batch 4131N 21602								
150	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
150 QC Quality Control	Memo	0.00	bx 12-7-23			DAS 24			

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 *160* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<i>SD</i>			<i>12-07-23</i>
170 *170* Packaging Packaging	Identify as per dwg & Stock Location: _____ <i>Backlot cell</i> Memo	0.00 0.00				<i>SD</i>			<i>12-07-23</i>
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							<i>12/7/24</i> <i>MLJ 12/07/23</i>

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Picklist Print

June-27-12 4:08:20 PM

Page 1

Work Order ID: 86396

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Parent Item: D3929-041

D3929-041

Parent Item Name: Gusset Assembly

Start Date: 27/06/2012

Required Date: 03/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S11GA

Purchased

No

100

sf

51.6260

0.45

2.842105

M304S11GA

304/316 0.125 Sheet

**

JM 12-6-28

Location

Loc Qty

Loc Code

MAT020

51.626

121380

23.9

121780

27.726

121780

D3907-1

Manufactured

No

130

Each

3.0000

2

12

D3907-1

Bushing

**

CC 12-7-23

Location

Loc Qty

Loc Code

WA

82786

3

3

B86059 →

3x 9x

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Dart Aerospace Ltd

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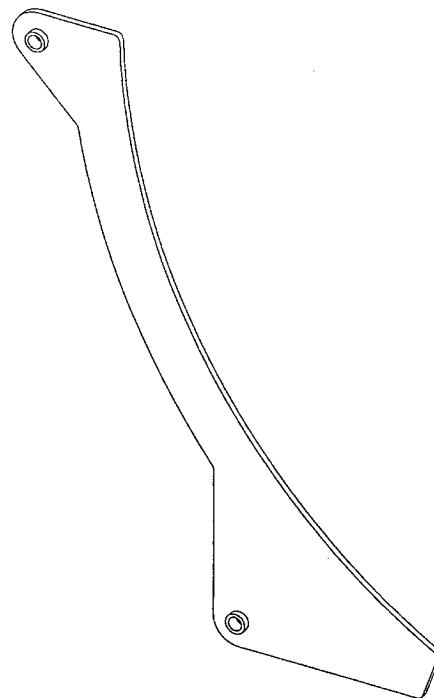
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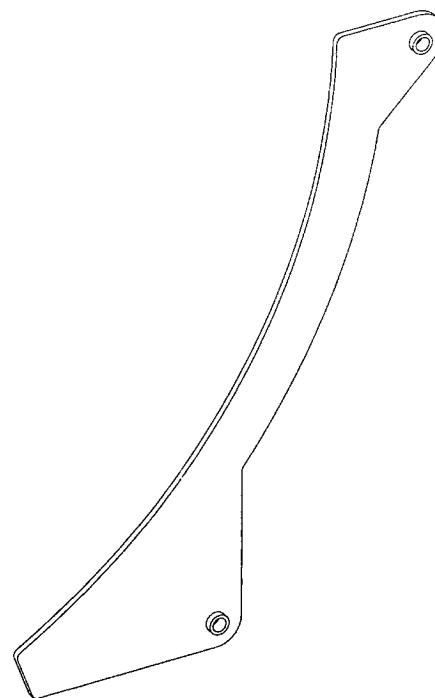
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86396 MCV
12/06/28

RELEASED
9/6/12 MD

A	NEW ISSUE	DESCRIPTION	MB	09.04.03
REV.			BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	09.04.03			

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.73 lbs EACH
 - 8) WELDING: PER DART QSI 004

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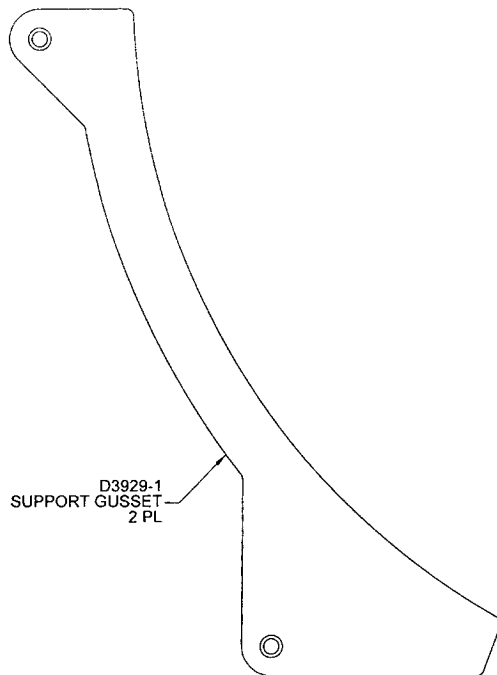
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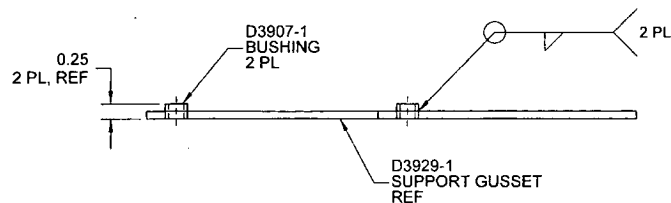
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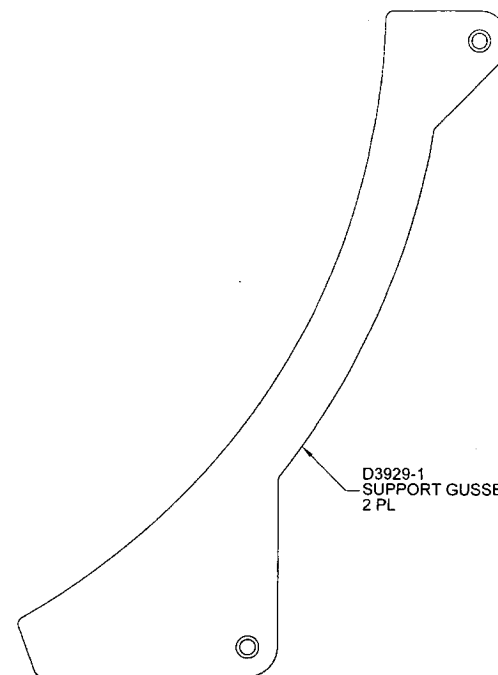


D3929-1
SUPPORT GUSSET
2 PL

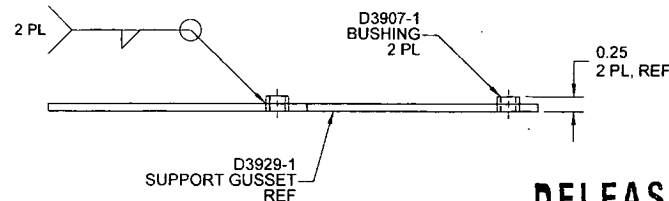


D3929-041 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
REF



D3929-1
SUPPORT GUSSET
2 PL



D3929-042 GUSSET ASSEMBLY

D3929-1
SUPPORT GUSSET
REF

RELEASED
09/04/22

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3929	REV. A
MFG. APPR.		SHEET 2 OF 3	
APPROVED		TITLE GUSSET ASSEMBLY	SCALE
DE APPR.		NTS	
DATE	09.04.03	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

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